

Work Order ID 86771

86771

Page 1

July-06-12 2:43:09 PM

Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Tube Assembly
 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: *12-07-9* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3391 | I |

| | | | | | | | | | |
|--------------|--------------------------------------|------|--|--|--|--|--|--|--|
| 100 | Skidtubes | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | Cut extrusion to 46.52 +0.010 -0.020 | | | | | | | | |

| | | | | | | | | | |
|----------------------|---|------|--|--|--|--|--|--|--|
| 110 | BENDING MACHINE - SKIDTUBES | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| CNC Bend I | Memo | 0.00 | | | | | | | |
| CNC Delta 100 Bender | Bend as per Dwg D3391 Using Bend Prog 3391021 | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6.79"

DAS
03
83

DP 12-7-31

Work Order ID 86771

86771

Page 2

July-06-12 2:43:09 PM

Item ID: D3391-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
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 Start Date: 7/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* HAAS 1 HAAS CNC vertical machine #1 | HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>I</u> Identify as D3391-1 2-Deburr | 0.00 0.00 | | B.A 12/08/07 | | 1 | 0 | | |
| 140 *140* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | B.A 12/08/07 | | 1 | 0 | | |
| 150 *150* Mill Conv Conventional Milling Machine | CONVENTIONAL MILLING MACHINE Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia | 0.00 0.00 | | 12-08-08 | | 1 | | | |

Work Order ID 86771

86771

Page 3

July-06-12 2:43:09 PM

Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Fwd Tube Assembly
 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12-08-08

12-8-13

Work Order ID 86771

86771

Page 4

July-06-12 2:43:09 PM

Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 *180* Skidtubes | Skidtubes | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | 1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step | | | | | | | | |
| | 2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A") | | | | | | | | |
| | 3-Open tow cap holes to .208" as per Dwg D3391 | | | | | | | | |
| | 4-Open Tow Ring hole to .640" as per Dwg D3391 | | | | | | | | |
| | 5- open float bag holes 0.328" and counter sink as per dwg D3391 | | | | | | | | |
| | 6-Deburr & Scribe Batch number Inside aft end. | | | | | | | | |
| | 7-Transfer drill D3391-021 with D3391-023 ***NO WEARPLATE HOLES ARE TRANSFER DRILLED*** | | | | | | | | |
| 190 *190* QC Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |

DC 12/09/05

DC 12/09/11

DAS 18 12/10/23

Work Order ID 86771

86771

Page 6

July-06-12 2:43:09 PM

Item ID: D3391-021 Accept *N900040100* Setup Start *NS1*
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 235 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| *235* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | AND REALODINE AS PER PAR09-043 | | | | | | | | |
| 240 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum. | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

m122878

START TIME: 8:10
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 8:40

1X 12/11/09

Work Order ID 86771

86771

Page 7

July-06-12 2:43:09 PM

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 Required Date: 7/06/12 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 250 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 1x | 4 | 11/11/13 | |
| Quality Control | | | | | | | | | |
| 255 | | 0.00 | | | | | | | |
| *255* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | 1x | 4 | 11/11/13 | |
| Skidtubes | **** install D3591-1 spacer as per DS19364 and wearplate as per DWG **** | | | | | | | | |
| 257 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *257* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |



Work Order ID 86771

July-06-12 2:43:09 PM

86771

Page 8

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 260 | Identify as per dwg & Stock Location: <u>wlo</u> | 0.00 | | | | | | | |
| *260* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 1x | 0 | 12/11/13 | |
| Packaging | | | | | | | | | |
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *280* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/11/22 *[Signature]*
 MF 12-11-21

Picklist Print

July-06-12 2:43:08 PM

Page 1

Work Order ID: 86771
Parent Item: D3391-021
Parent Item Name: Fwd Tube Assembly

Start Date: 7/06/12
Start Qty: 1.00

Required Date: 7/06/12
Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
IPP B06.02.10Dwg rev.D ecn 773 EC
IPP C06.05.02Added inspections EC
IPP D 07.03.13 rev F dwg EC
IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J 11.11.14 AS PER REV.I
DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D4095-051 Wearpad Assembly | | Manufactured | No | | | 255 | Each | 23.0000 | 1 | 1 | | 12/11/13 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | FP002 | | 23 | | | | | | | |
| | | | | 81613 | | 11 | | | | | | | |
| | | | | 85601 | | 12 | | | | | | | |
| D6013-047 Skidtube Material | | Manufactured | No | | | 100 | Each | 81.0000 | 1 | 1 | | DC 12/07/30 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG | | 81 | | | | | | | |
| | | | | 72505 | | 81 | | | | | | | |
| D3670-4-200 SPACER | | Manufactured | No | | | 220 | Each | 98.0000 | 4 | 4 | | DC 12/10/23 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG | | 46 | | | | | | | |
| | | | | 80360 | | 40 | | | | | | | |
| | | | | 84504 | | 6 | | | | | | | |
| | | | | LG001 | | 52 | | | | | | | |
| | | | | 78606 | | 4 | | | | | | | |
| | | | | 81972 | | 7 | | | | | | | |
| | | | | 85460 | | 41 | | | | | | | |

Picklist Print

July-06-12 2:43:09 PM

Page 2

Work Order ID: 86771
Parent Item: D3391-021
Parent Item Name: Fwd Tube Assembly

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

D3401-041 Manufactured No
Tow Cap Assembly

255 Each 11.0000

1 HL 1 12/11/13

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 11 | |
| 82302 | 8 | B85510 |
| 83432 | 3 | |

X1

AN960C10L washer * NAS1149C0332R Purchased No

255 Each 21.0000

10 HL 10 12/11/13

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST | 21 | |
| 107534 | 21 | M123355 |

X10

AN3C4A BOLT Purchased No

255 Each 4,260.0000

10 HL 10 12/11/13

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST350 | 4260 | |
| 120187 | 31 | M122814 |
| 120521 | 28 | |
| 120769 | 38 | |
| 121205 | 155 | |
| 121556 | 8 | |
| 122151 | 4000 | |

X10

D3672-1 Phenolic Washer Manufactured No

255 Each 1,362.0000

4 HL 4 12/11/13

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST060 | 1362 | |
| 72229 | 4 | |
| 76277 | 13 | |
| 80369 | 335 | |
| 83608 | 500 | |
| 85222 | 510 | |

X1

AELS-1032-225 INSERT * ALS7-1032-225 Purchased No

255 Each 0.0000
M122290

10 (X10) 10 HL 12/11/13

July-06-12 2:43:09 PM

Shop Packet Print

Page 2

SHOP COPY

RETURN TO

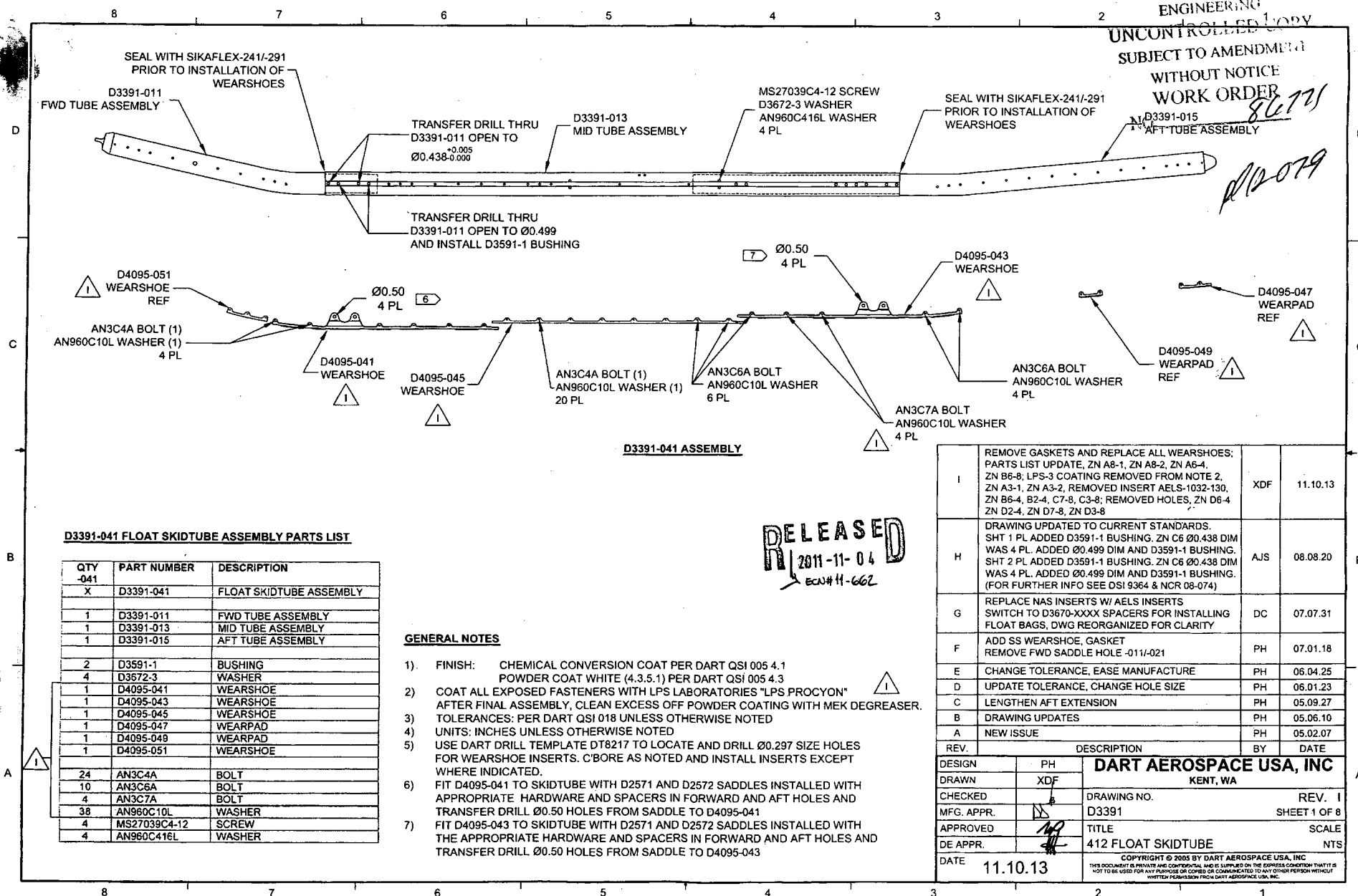
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

D3391-015
AFT TUBE ASSEMBLY86721
12079**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|-------------------------|
| X | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D3391-015 | AFT TUBE ASSEMBLY |
| 2 | D3591-1 | BUSHING |
| 4 | D3672-3 | WASHER |
| 1 | D4095-041 | WEARSHOE |
| 1 | D4095-043 | WEARSHOE |
| 1 | D4095-045 | WEARSHOE |
| 1 | D4095-047 | WEARPAD |
| 1 | D4095-049 | WEARPAD |
| 1 | D4095-051 | WEARSHOE |
| 24 | AN3C4A | BOLT |
| 10 | AN3C6A | BOLT |
| 4 | AN3C7A | BOLT |
| 38 | AN960C10L | WASHER |
| 4 | MS27039C4-12 | SCREW |
| 4 | AN960C416L | WASHER |

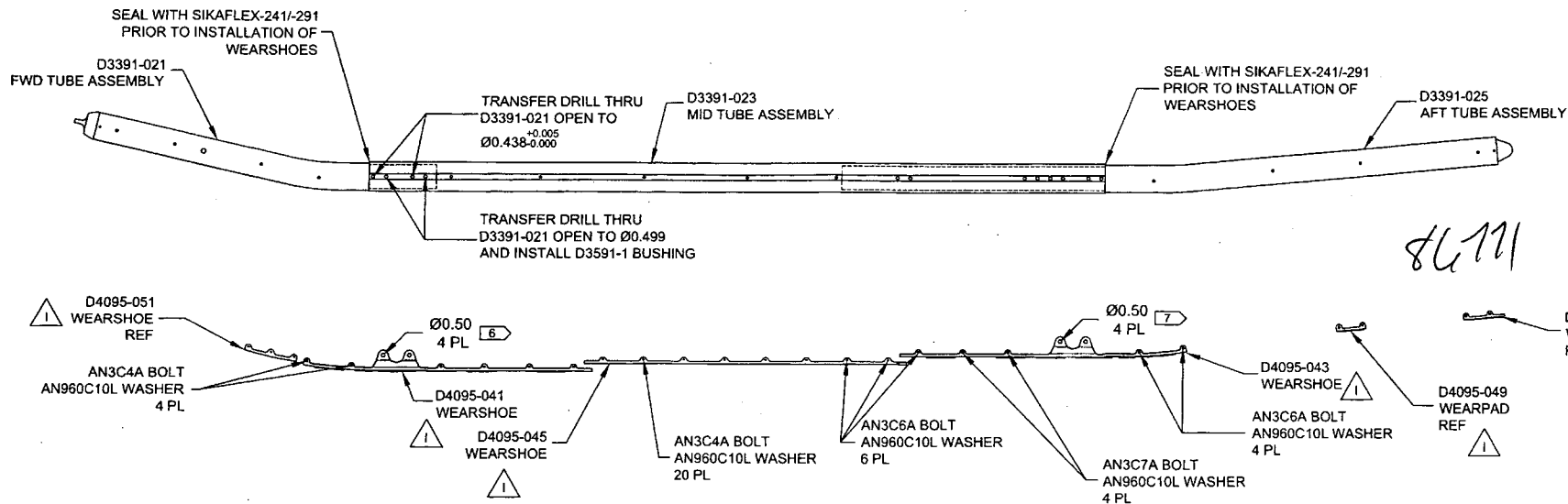
GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN#11-662

| | | | |
|------------|--|-----|----------|
| I | REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8, LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8 | XDF | 11.10.13 |
| H | DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 $\varnothing 0.438$ DIM WAS 4 PL. ADDED $\varnothing 0.499$ DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 $\varnothing 0.438$ DIM WAS 4 PL. ADDED $\varnothing 0.499$ DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074) | AJS | 08.08.20 |
| G | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021 | PH | 07.01.18 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION | PH | 05.09.27 |
| B | DRAWING UPDATES | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.02.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | | |
| DRAWN | XDF | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.10.13 | | |

DART AEROSPACE USA, INC
KENT, WADRAWING NO. D3391
REV. I
SHEET 1 OF 8TITLE 412 FLOAT SKIDTUBE
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

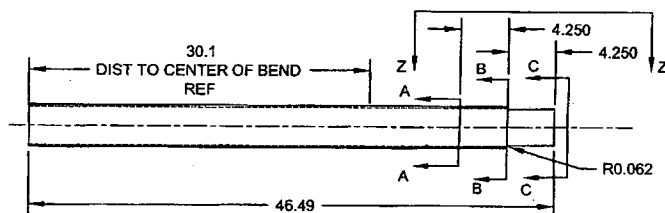
| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-------------------------|
| X | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 2 | D3591-1 | BUSHING |
| 1 | D4095-041 | WEARSHOE |
| 1 | D4095-043 | WEARSHOE |
| 1 | D4095-045 | WEARSHOE |
| 1 | D4095-047 | WEARSHOE |
| 1 | D4095-049 | WEARPAD |
| 1 | D4095-051 | WEARSHOE |
| 24 | AN3C4A | BOLT |
| 10 | AN3C6A | BOLT |
| 4 | AN3C7A | BOLT |
| 38 | AN960C10L | WASHER |

GENERAL NOTES

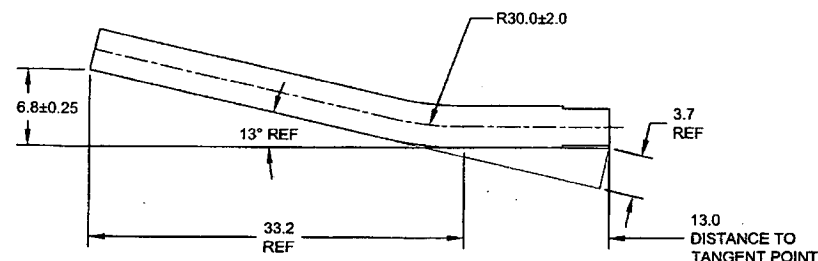
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

| | | | |
|--|---|---|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED |  | DRAWING NO. | REV. |
| MFG. APPR. |  | D3391 | SHEET 2 OF 8 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | 412 FLOAT SKIDTUBE | NTS |
| DATE | 11.10.13 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |
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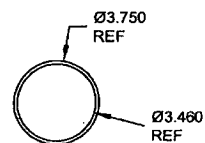
RELEASED
2011-11-04



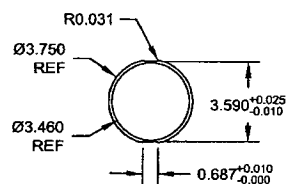
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



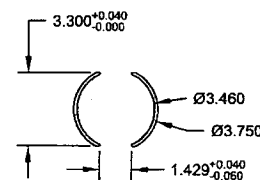
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



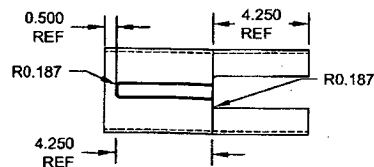
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



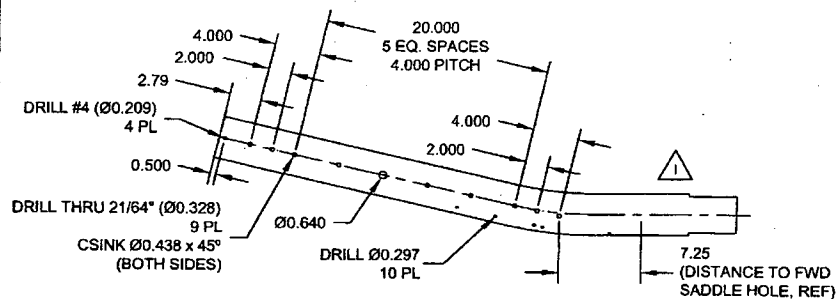
SECTION C-C
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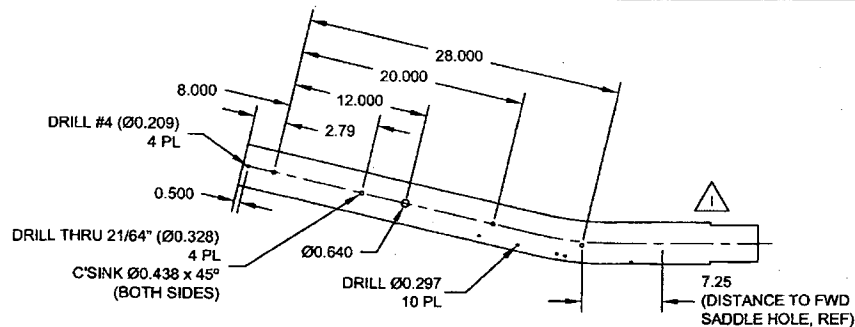
VIEW Z-Z
SCALE 2X

RELEASED
2011-11-04

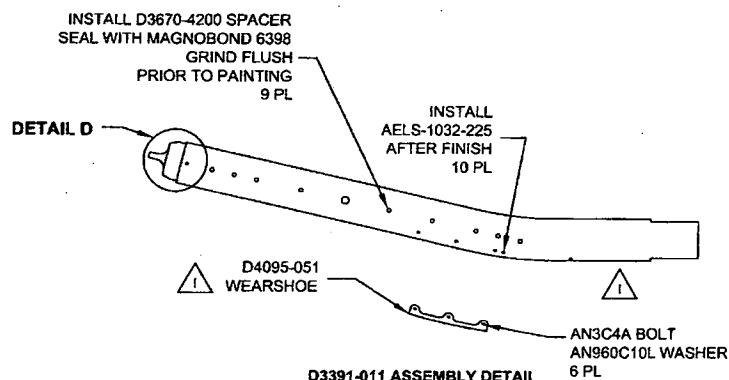
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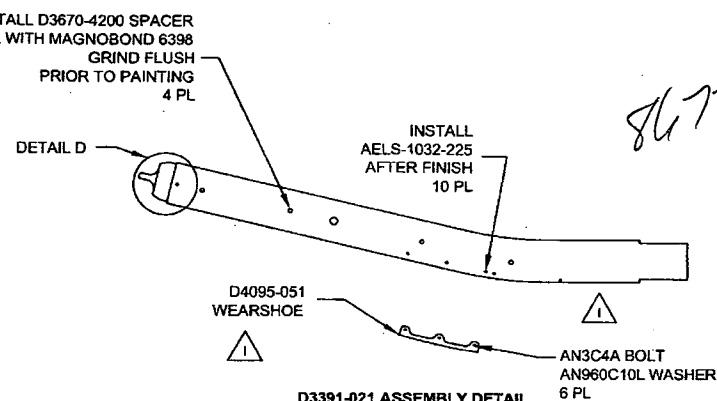
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

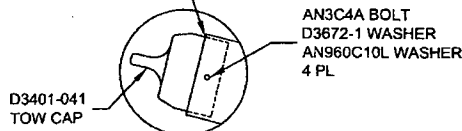


D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY - 011 | QTY - 021 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | | D3391-011 | FWD TUBE ASSEMBLY |
| | X | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D3401-041 | TOW CAP |
| 9 | 4 | D3670-4200 | SPACER |
| 4 | 4 | D3672-1 | WASHER |
| 1 | 1 | D4095-051 | WEARSHOE |
| 1 | 1 | D6013-047 | FWD TUBE |
| 10 | 10 | AN3C4A | BOLT |
| 10 | 10 | AN960C10L | WASHER |
| 10 | 10 | AELS-1032-225 | INSERT |

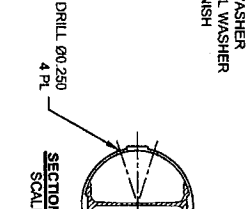
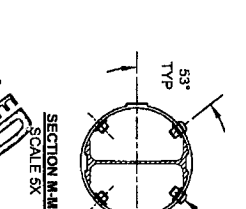
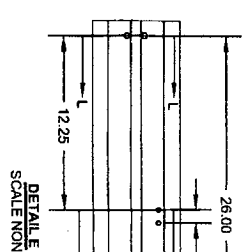
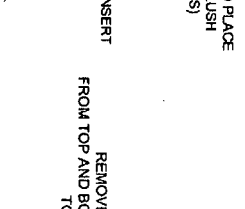
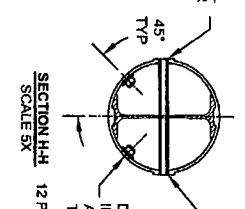
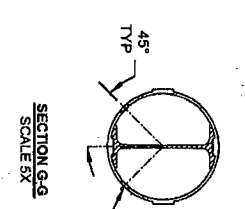
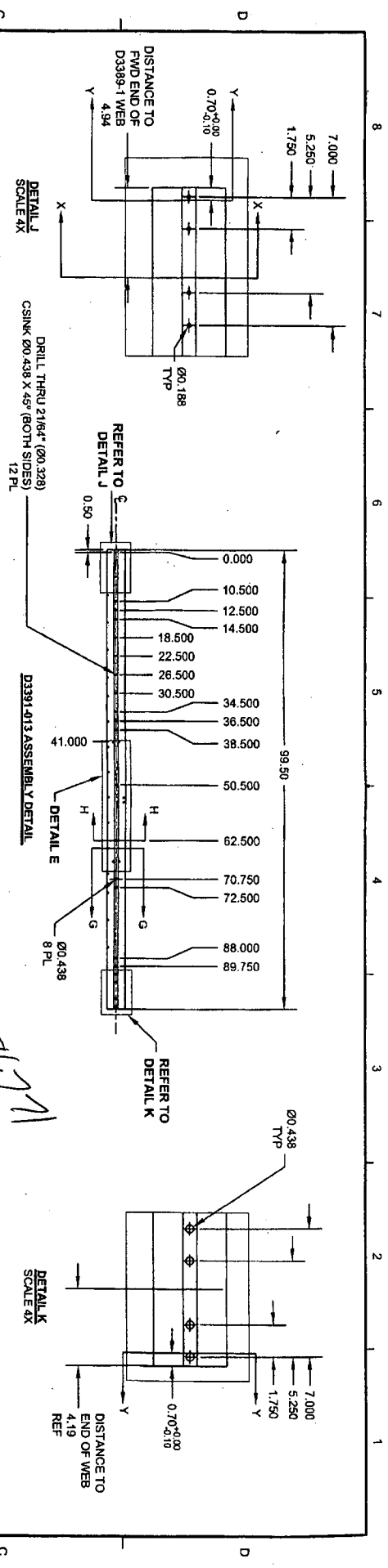
SEAL WITH SIKAFLEX-2411-291



**DETAIL D
SCALE 2X**

| | | | | | |
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| MFG APPR. | | | | D3391 SHEET 4 OF 8 | |
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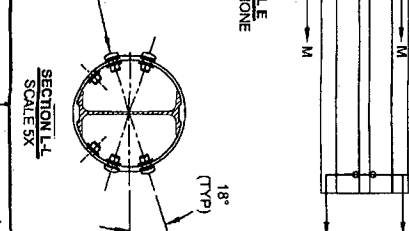
RELEASED
2011-11-04



D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|-------------------|
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 12 | D3681-1 | SPACER |
| 24 | A/S-1032-130 | INSERT |
| 4 | A/S-428-165 | INSERT |
| 4 | AN980C10L | WASHER |
| 4 | AN980C41BL | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |

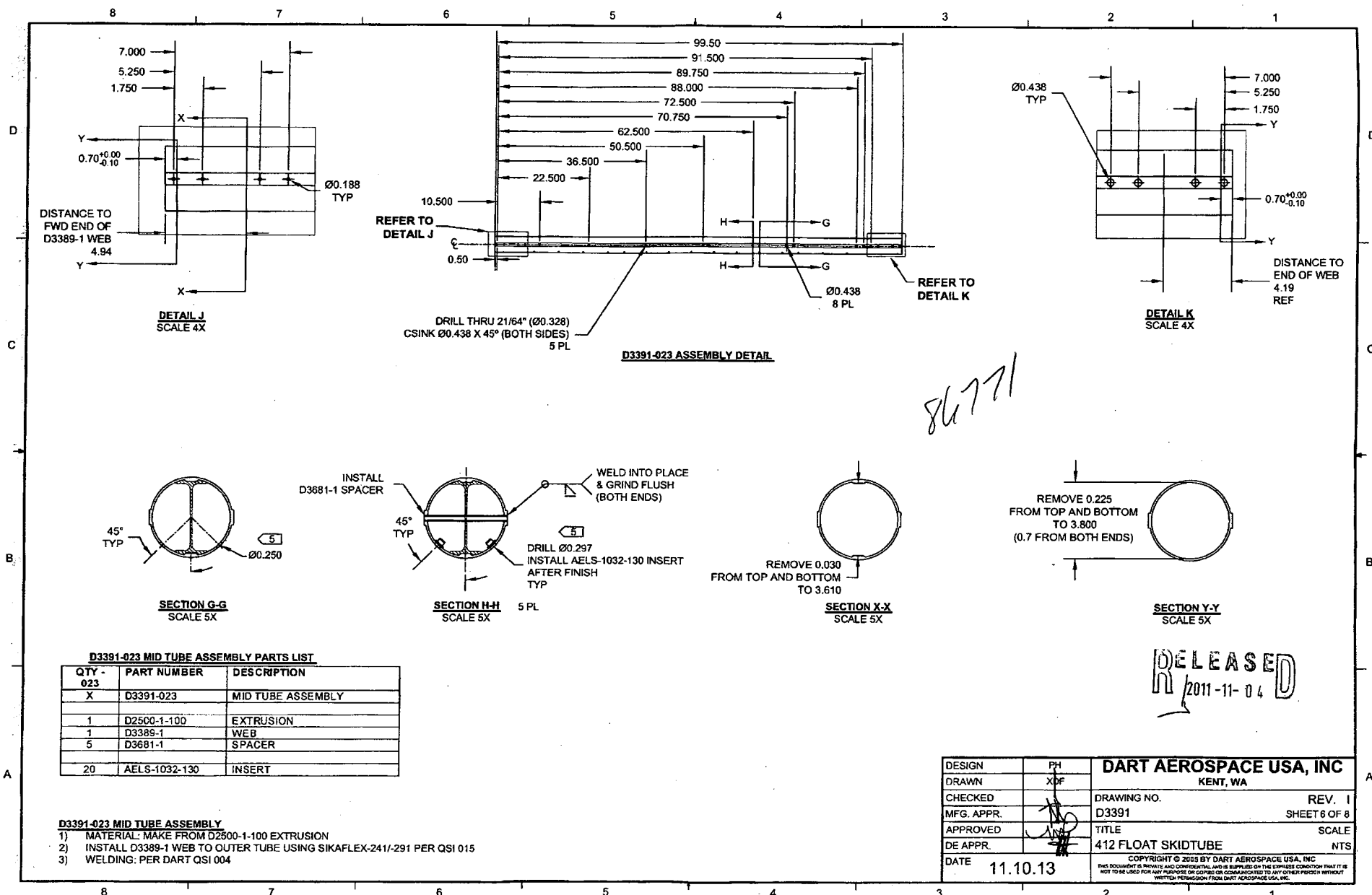
INSTALL A/S-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN980C41BL WASHER
AFTER FINISH
4 PL

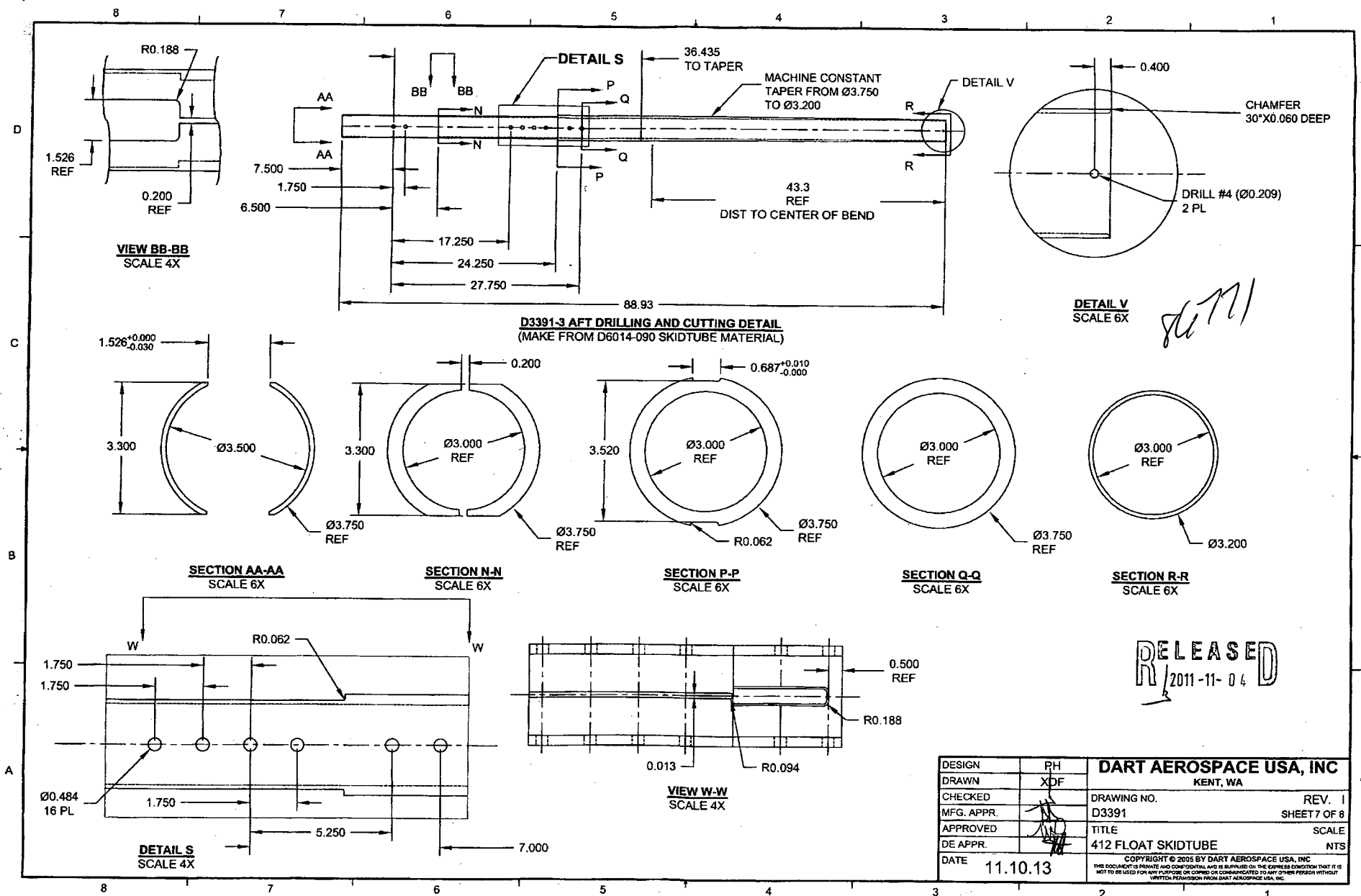


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KENT, WA
REV. 1
SHEET 5 OF 8
SCALE
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